



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2580-1

Job Sheet 177925



Part No: D2580-1

Job Qty: 4 ea

Part Name: 205 Bent Tube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/23/18

Job Tracking No:

Due Date: 6/6/18

Created By: Jesse White

Type: Stock

Description:

Note: DWG D2580 REV h SHEETS 1,2,3,8 IPP B 01.11.08 Revised Step 9, 10, 12, and 13 SM IPP Rev:C 10.12.01 as per DEO D1 DD ver:ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	6/6/18	6/6/18	0.00	0.00	Start Up Skid tubes		DD
100	Skid tubes	4 pcs	6/6/18	6/6/18	0.00	3.70	Skid tubes		DD
101	QC	4 pcs	6/6/18	6/6/18	0.00	0.00	QC5		BE
110	HandFinish	4 pcs	6/6/18	6/6/18	0.00	1.67	HandFinish1		SA 18-05-30
120	QC	4 pcs	6/6/18	6/6/18	0.00	0.00	QC7		BE
125	Skid tubes	4 pcs	6/6/18	6/6/18	0.00	3.70	Skid tubes		BE
130	QC	4 pcs	6/6/18	6/6/18	0.00	0.00	QC5		BE
140	Packaging	4 pcs	6/6/18	6/6/18	0.00	0.00	Packaging3		DD
150	QC21-SA	4 Ea	6/6/18	6/6/18	0.00	0.00	QC21		21 JUN 06 2018

Part Op 100 - 1- Inspect mat'l D2500-1-190 for damage. 2-Drill pilot holes using drill jig DT 8149 A-BC-D 3-Open holes to 0.508" Descriptions: as per Dwg D2580 4-Debur holes per QSI002 section 4.2.3 and blow out all chips from inside of tube 5- Test fit inspection saddles on FWD & AFT saddle holes using DT9916.

125 - 1- Bond web in place per QSI 015. A/R Sikaflex-291 batch: M136 787 Sikaflex expire date: Dec 2018 Start time and date: May 31st bond for 12hrs

140 - LOCATION : LG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-1-190	Ext'n -1' Beam Tube 4"	4 Ea (1 ea)	90-Start up Operation	302762 503056
D2596	Web, 205 Skid tube	4 Ea (1 ea)	125-Skid tubes	5070483

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2500-1-190	4	45	0
125-Skid tubes	D2596	4	17	0

Part Specifications

Specifications could not be found.



Container No: S076456



Part: D2580-1

Job No: 177925

Serial No/Batch: S076456

Revision: H

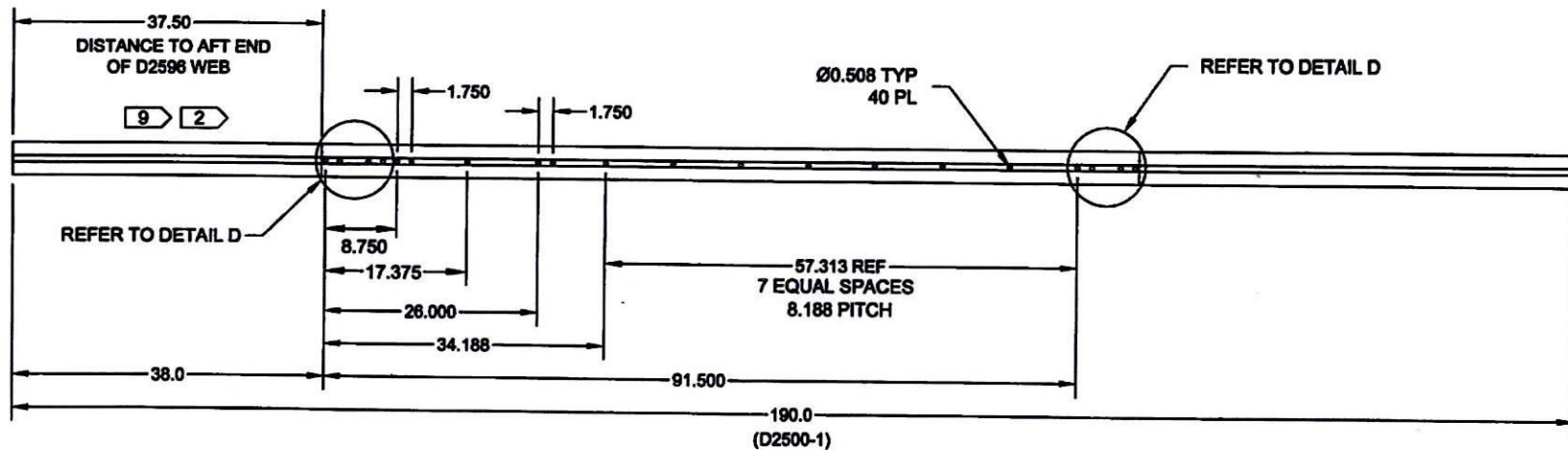
Inspector:

Exp Date: 05/30/2018

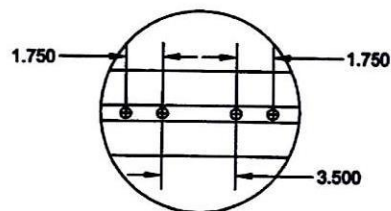
Instructions:

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Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/30/18



D2580-101 TUBE



DETAIL D
SCALE 5X

RELEASED

2017 JUL 05

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	<i>[Signature]</i>	DRAWING NO. D2580	REV. H SHEET 9 OF 9
MFG. APPR.	<i>[Signature]</i>	TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
DATE	17.06.09	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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